

Work Order ID 72969

Tuesday, August 23, 2011 8:11:27 AM

Page 1

Item ID: D2571

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Fwd Out 205

Start Date: 8/23/2011 Start Qty: 14.00

Cust Item ID:

Required Date: 9/7/2011 Req'd Qty: 14.00

Customer:

Reference:

Approvals: Process Plan:

Date: 11-08-23 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 72969 Double check by: 22 11-8-31
per Folio FA051 and inspect per attached Dimension Sheets 12-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets 13-Machine
Step No 3 per Folio FA051 and inspect

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72969

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Accept



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Stop



Item Name: Saddle. Fwd Out 205

Start Date: 8/23/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 9/7/2011 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M 117745

320°F

11:00

11:30

12x0 m-f 11/09/07

12x0 m-f 11/09/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72969

Tuesday, August 23, 2011 8:11:27 AM



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 8/23/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 9/7/2011 Req'd Qty: 14.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 d M 11/09/07

170

Identify as per dwg & Stock Location: ST 433

0.00



Packaging

Memo

0.00

Packaging

SP

(12x)

SP 11-09-08

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/08

mf 11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 23, 2011 8:11:33 AM

Page 1

Work Order ID: 72969

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205



Start Date: 8/23/2011

Required Date: 9/7/2011

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP: 11/02/10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 [KJ]

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007

Manufactured

No

100

Each

45.0000

1

14



Saddle Billet



FK, RQ 11.8.31

Location

Loc Qty

Loc Code

MAT

14

71722 ✓

14

MAT042

8

72228 ✓

8

MAT045

23

65383

1

65954

4

70680

18

6
86

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72969
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.001	8.000	8.003		
F	0.490	0.510		.501	.500	.503	.506		
G	0.257	0.262		.257	.257	.257	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.503	.503	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.567	.568		
L	1.174	1.184		1.174	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.132	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.257	.250	.250		
S	0.115	0.135		.128	.129	.129	.128		
T	0.178	0.198		.188	.189	.188	.189		
U	2.940	2.980		2.961	2.961	2.961	2.961		
V	0.230	0.250		.243	.243	.240	.241		
W	0.115	0.135		.120	.120	.120	.120		
X	0.308	0.313		.311	.311	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.364	.362		
AA	0.470	0.530		.50	.50	.50	.50		
AB	0.615	0.635		.628	.629	.628	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.253	.253	.250	.250		
AE	1.375	1.395		1.387	1.387	1.388	1.388		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.260	.260	.250	.250		
AI	2.000	2.020		2.001	2.002	2.001	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: FK. / RP	Audited by: [Signature]
Date: 11/09/02	Date: 11/11/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72 969
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	37	48		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.003	8.003	8.003		
F	0.490	0.510		.503	.503	.503	.503		
G	0.257	0.262		.258	.259	.259	.259		
H	0.375	0.380		.375	.377	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.569	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.506	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.124	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.129	.129	.129	.129		
T	0.178	0.198	.188	.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.242	.242	.242		
W	0.115	0.135		.120	.120	.120	.120		
X	0.308	0.313		.310	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.370	.370	.370		
AA	0.470	0.530		.50	.50	.50	.50		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.253	.253	.253	.253		
AE	1.375	1.395		1.387	1.389	1.389	1.389		
AF	0.115	0.135		.120	.130	.120	.120		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.260	.260	.260	.260		
AI	2.000	2.020		2.002	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	aml
Date:	11/09/15

Audited by:	SA
Date:	11/9/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72 969
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	#11	#12		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.001	8.001	8.001		
F	0.490	0.510		.503	.498	.499	.503		
G	0.257	0.262		.258	.259	.259	.259		
H	0.375	0.380		.375	.376	.376	.376		
I	0.490	0.510		.500	.497	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.564	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.124	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.129	.127	.126	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.243	.240	.241	.239		
W	0.115	0.135		.120	.120	.120	.122		
X	0.308	0.313		.311	.310	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.367	.367	.366		
AA	0.470	0.530		.50	.500	.500	.500		
AB	0.615	0.635		.628	.629	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.253	.247	.247	.247		
AE	1.375	1.395		1.387	1.387	1.387	1.387		
AF	0.115	0.135		.135	.128	.128	.128		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.260	.248	.248	.247		
AI	2.000	2.020		2.000	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	one
Date:	11/09/03

Audited by:	SA
Date:	11/9/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

